

Work Order ID 120444

120444

Page 1

June-12-14, 12:49:38 PM

Item ID: D2432

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw 19" X 24"

Start Date: 6/04/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

H

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24591
Cut Blank as per D2432 File

CL 14/06/13 8

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

8x SP 14-6-26

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

CL 14/09/07 8

Work Order ID 120444

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Item ID: D2432 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw 19" X 24"
 Start Date: 6/04/14 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	0.00 0.00				8			JFC 2014-09-08
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				8			JFC 2014-09-08
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							DAS 40 9-89 14/09/16

Work Order ID 120444

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120444

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Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw 19" X 24"
Start Date: 6/04/14 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/04/14 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>PP120377</u>	0.00				<u>8</u>	<u>76</u>	<u>14-9-16</u>	
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14/9/17 8

14-8-16

Picklist Print

June-12-14 12:49:37 PM

Work Order ID: 120444

120444

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	773.3000	3.7	29.6			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

02/14/06/19

Location

Loc Qty

Loc Code

MAT

400

m129293

400

29.6

MAT018

373.3

m128267

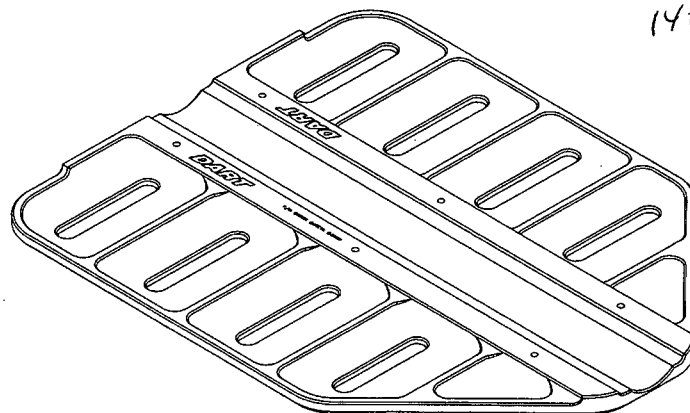
47

m128668

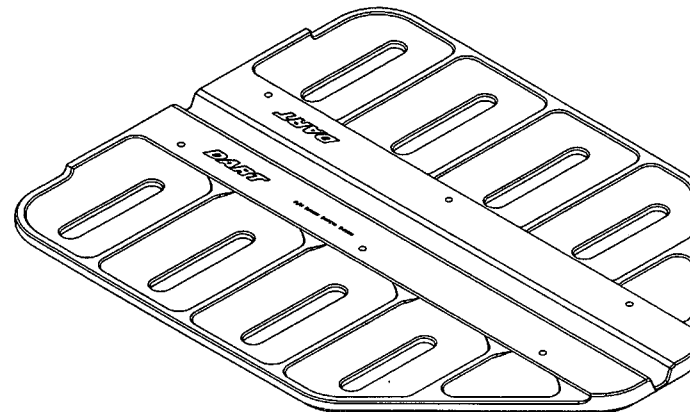
326.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120444 MCG

1406-06



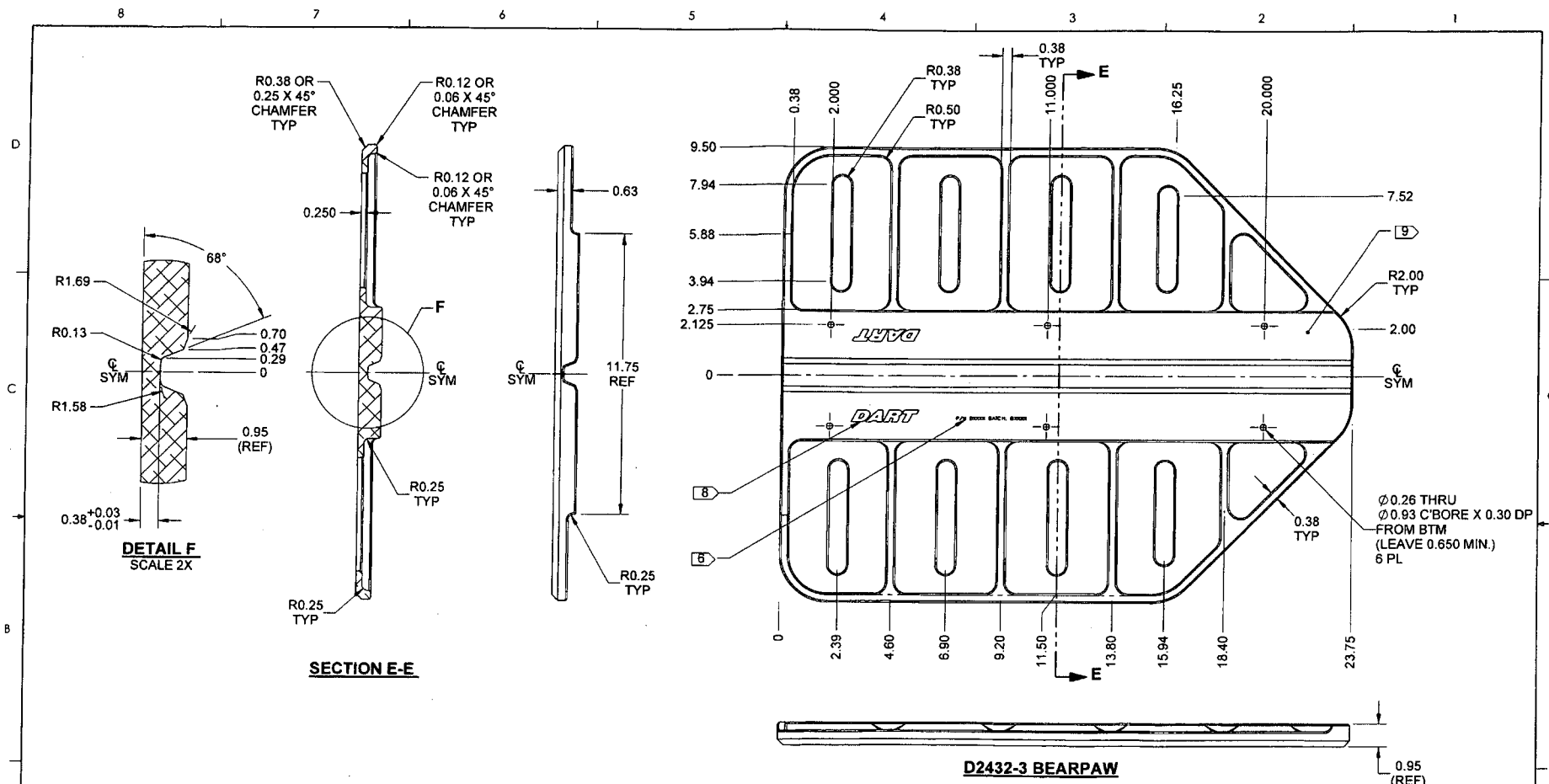
D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	AT	D2432	SHEET 1 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	TH	BEARPAW	NTS
DATE	12.09.24	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION E-E

DETAIL F
SCALE 2X

D2432-3 BEARPAW

RELEASED
2012-10-16

- NOTES:
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
 - 7) WEIGHT: 6.25 lbs
 - 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
 - 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
 - 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO. D2432	REV. H
MFG. APPR.	9/1	SHEET 3 OF 3	
APPROVED	14/1	TITLE BEARPAW	SCALE
DE APPR.		NTS	
DATE	12.09.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24591**

Purchase Order Date 6/13/2014

PO Print Date 6/13/2014

Page Number 1 of 2

Order From :

VC-TPI001

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: TST ground

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	120444	D2432 BEARPAW	6/30/2014 Yes 6/30/2014		8.00 ✓	\$29.90	\$239.20
	CUT AS PER DWG D2432 REV. H						
						Line Total:	\$239.20
2	120882	D4353-041 BEARPAW	6/30/2014 Yes 6/30/2014		4.00 ✓	\$43.28	\$173.12
	CUT AS PER DWG D4353 REV. B						
						Line Total:	\$173.12
3	71401-45	PROCUREMENT QUALITY CLAUSES	6/30/2014 No 6/30/2014		1.00 ✓	\$0.00	\$0.00
	Quality Procurement Clauses A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A042 DART NOTIFICATION BY SUPPLIER						

SP 14-6-26

Note:

6/13/2014

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6161
Date: 2014-06-25
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24591	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-06-25
Tracking No.:	

Item No	Unit	Description	Quantity
d2432 d4353-041	Chaque Chaque	d2432 bearpaw d4353-041 bearpaw	8 4

SP 14-6-26

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days

